Work Orde Tuesday, June 29										-			Page
Item ID: Revision ID:	D4051-3					Accept				S	Setup Star	i indiiidi n	
	Bracket 6/29/2010 7/6/2010	Start Qty: Req'd Qty:					Cust Ite Custome				Stop	P	
Approvals:	Process Plan	n:		Date:	362	Tooling: SPC (Y/N):		Date:		F	Run Stai Sto	1 18811161 1	
Sequence ID/ Work Center ID		Operation Description				Set Up/ Run Hours	Tool II	D Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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D4051	a												
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0.00

0.00

13,0-7-

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspect
Part No	);	PAR #:	Fault Cat	egory:	_ NCF	l: Yes	No <b>DQ</b>		Date: _	
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Tuesday, June 29, 2010 11:38:38 AM



Page 2

Item ID:

D4051-3

**Revision ID:** 

Item Name: Bracket

**Start Date:** 

6/29/2010

QC:

Required Date: 7/6/2010

Start Qty: 2.00 Req'd Qty: 2.00



Accept



Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date:\_\_\_\_\_

Date: Tooling:

SPC (Y/N):

Date:

Customer:

**Cust Item ID:** 

Date:

Start Run

Stop



Sequence ID/

**Work Center ID** 

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Memo

QC5- Inspect part completeness to step on W/O

Set Up/ Run Hours

Tool ID

Tool # Plan

Qty Code

Accept

Reject Qty

Reject Number Stamp

Insp.

130



Brake NC Brake NC

Bend as per dwg

0.00

0.00

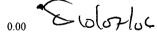
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Memo

0.00



**Quality Control** 

W/O:									
DATE	STEP	PRO	CEDURE CH	IANGE	Ву	Date	ety	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	Fault Ca	tegory:	_ NCR: Yes	No DQA:	.: Date:		
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### Work Order ID 60223

Tuesday, June 29, 2010 11:38:38 AM



Page 3

Item ID:

D4051-3

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Bracket

**Start Date:** 6/29/2010

Start Qty: 2.00

Required Date: 7/6/2010

Req'd Qty: 2.00



**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

Date: Date: Run 1 Start

1 Stop



Sequence ID/

Work Center ID

150

Packaging

Operation Description

Identify as per dwg & Stock Location

0.00

Tool ID **Run Hours** 

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Packaging

Memo

0.00

10.07.00

160

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

pl 10-7-06 (6)

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## **Picklist Print**

Tuesday, June 29, 2010 11:38:43 AM

Work Order ID: 60223

Parent Item: D4051-3

Parent Item Name: Bracket



**Start Date:** 6/29/2010

Required Date: 7/6/2010

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 10.01.12 verified by:EC REV.A DD 10.02.22 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty Qty Issued	Date Status Issued
M304S16GA		Purchased	No		100	sf	77.2439	0.01408	0.029642	, <del>58</del>
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304/316 Sheet .063

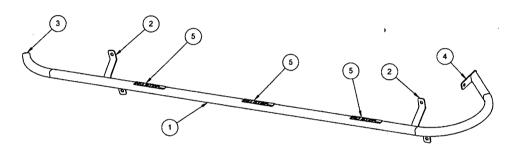
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RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. CO223-PS/10-6-29

QTY -041 ITEM P/N DESCRIPTION D4051-041 RAPPEL DEFLECTOR ASSY х D4051-042 RAPPEL DEFLECTOR ASSY D4051-1 RAPPEL DEFLECTOR 1 D4051-3 BRACKET DΙ D4051-7 FILLER 4 D4051-5 MOUNTING PLATE 3 D4051-9 PLACARD



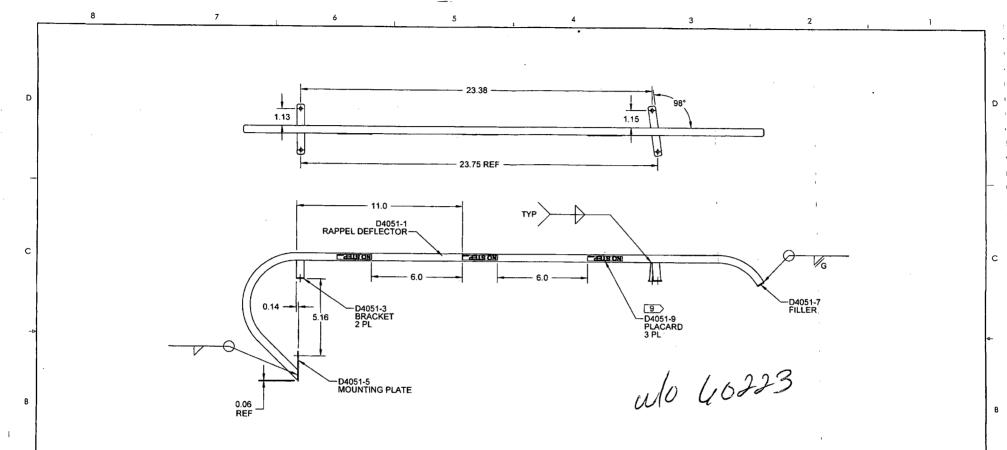
D4051-041 RAPPEL DEFLECTOR ASSY (SHOWN) D4051-042 RAPPEL DEFLECTOR ASSY (OPPOSITE)

Α	NEW ISSU	E		¹ RF	10.01.29				
REV.			DESCRIPTION	BY	DATE				
DESIGN RF			DART AEROSPACE LTD						
DRAW	N	RF	HAWKESBURY, ONTARIO, CANADA						
CHECKED (1)		W	DRAWING NO.	REV. A					
MFG. APPR.		N	D4051		SHEET 1 OF 7				
APPRO	OVED	143	TITLE		SCALE				
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#### **D4051-041 RAPPEL DEFLECTOR ASSY**

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4051-041" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 1.07 lbe 7) WEIGHT: 1.07 Ibs 8) WELD PER DART QSI 004 9) APPLY D4051-9 PLACARD AFTER POWDER COAT

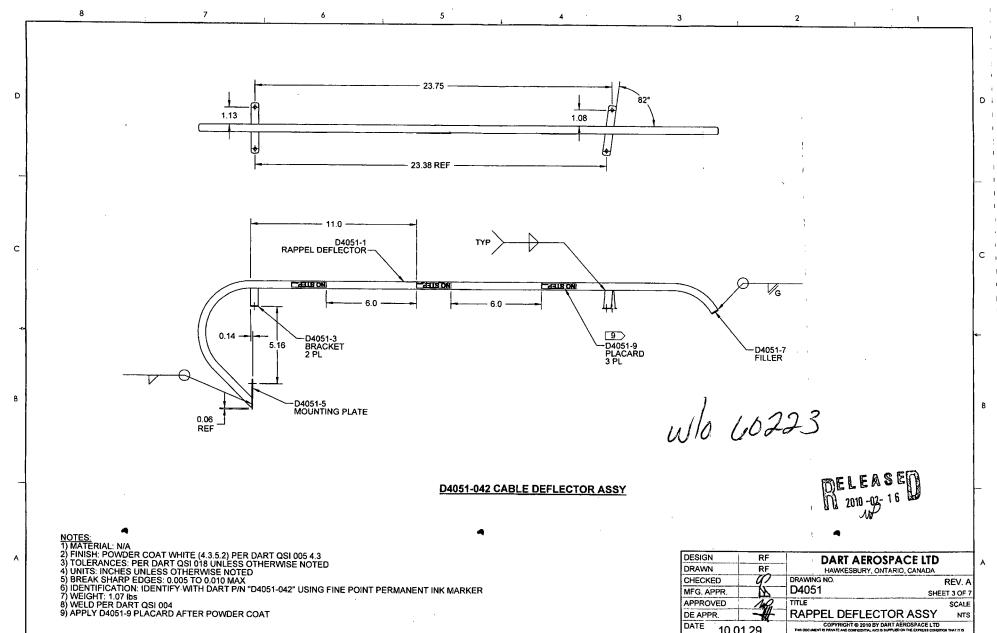
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#### 8 D4051-1 RAPPEL DEFLECTOR

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 x 0.50 x 0.049 WALL REF DART SPEC. M304TS0.500W.049
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.98 lbs
8) TUBE FLAT LENGTH 43.00 REF

DESIGN DART AEROSPACE LTD DRAWN RF HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4051 MFG. APPR. SHEET 4 OF 7 APPROVED TITLE RAPPEL DEFLECTOR ASSY NT.

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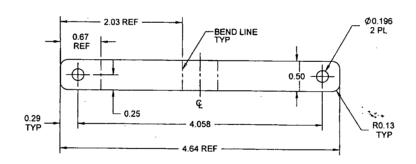
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D4051-3 BRACKET (MAKE FROM D4051-3F FLAT PATTERN)



**D4051-3F FLAT PATTERN** 

who 40223

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE

7) WEIGHT: 0.03 lbs

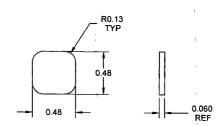
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**D4051-5 MOUNTING PLATE** 

**D4051-7 FILLER** 

NOTES:
1) MATÉRIAL: AISI 304/316 STAINLESS STEEL SHEET 0.060 THICK ANNEALED 2B FINISH PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA

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PER DART SPEC INJUGS 1005

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D4051-5: 0.02 lbs

D4051-7: 0.004 lbs

DESIGN	RF	DART AEROSPACE LTD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA			
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D4051-9 PLACARD

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NOTES:
1) MATERIAL: RED LETTERS ON WHITE BACKGROUND AND SELF-ADHESIVE BACK.
MANUFACTURE FROM 3M 7 MIL MASKING FILM #8522CP OR AVERY IPM #2031
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: N/A

DESIGN	RF	DART AEROSPACE LTD	
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DART AEROSPACE LTD	. Work Order:	60393
Description: BRACKET	Part Number:	D4051-3
Inspection Dwg: \\4051-3 Rev:		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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Measured by:		Audited by:	Prototype Approval:	N/A
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Date:	10-1-1	[ ]	Revised by	Approved
Rev Date	Change		Revised by	Approved

New Issue